

Work Order ID 68163

Thursday, April 07, 2011 11:12:27 AM



Page 1

Item ID: D4274-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate, Fwd Support

Start Date: 4/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/14/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

11

Date:

11-04-1

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4274

B

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: *B*

Prog Rev: *B*

304 .125

2-Deburr if necessary

B11-4-8

6

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-4-8

W/O:		WORK ORDER CHANGES					
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Page 2

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Start Date: 4/7/2011 Start Qty: 6.00



Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

ml 11 04 11 (6)

130

Identify as per dwg & Stock Location: ST 139B 0.00

Packaging

Memo

0.00

Packaging

ES 11/04/14 (6)

140

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

11/4/15 (6)

11/11/04/14 (6)

Dart Aerospace Ltd

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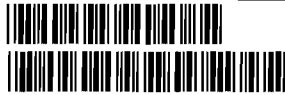
NOTE: Date & initial all entries

Picklist Print

Thursday, April 07, 2011 11:12:34 AM

Page 1

Work Order ID: 68163



Parent Item: D4274-1

Parent Item Name: Plate, Fwd Support



Start Date: 4/7/2011

Required Date: 4/14/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP rev:A 10.11.18 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA  304/316 0.125 Sheet		Purchased	No			100	sf	23.0000	0.357 	2.254737 RL 4-8			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT020		23							
				116623		23			116623				

Dart Aerospace Ltd

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DART AEROSPACE LTD		Work Order:	48163
Description: Plate, Fwd Support		Part Number:	D4274-1
Inspection Dwg: D4274 Rev: B		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.131	x		V HB2	
Ø0.191	+0.005/-0.001	.192	>		V	
Ø0.257	+0.006/-0.001	.257	>		V	
4.40	+/-0.030	4.411	>		V	
1.40	+/-0.030	1.406	>		V	
0.335	+/-0.010	.333	>		V	
0.750	+/-0.010	.747	>		V	
0.380	+/-0.010	.379	>		V	
1.30	+/-0.030	1.307	>		V	
5.70	+/-0.030	5.709	>		V	
4.35	+/-0.030	4.362	>		V	
7.11	+/-0.030	7.115	x		V	
2.80	+/-0.030	2.796	>		V	
1.75	+/-0.030	1.749	x		V	
1.05	+/-0.030	1.048	x		V	
0.303	+/-0.010	.303	x		V	
0.375	+/-0.010	.375	>		V	
0.90	+/-0.030	.899	<		V	
0.75	+/-0.030	.753	>		V	
0.25	+/-0.030	.25	>		V	
3.000	+/-0.010	3.002	<		V	
1.500	+/-0.010	1.501	x		V	
2.300	+/-0.010	2.303	>		V	
1.20	+/-0.030	1.211	>		V	
1.10	+/-0.030	1.090	>		V	
2.660	+/-0.010	2.666	<		V	
1.330	+/-0.010	1.333	>		V	
0.40	+/-0.030	.401	>		V	
0.25	+/-0.030	.25	>		V	
1.900	+/-0.010	1.901	>		V	
0.25	+/-0.030	.25	<		V	

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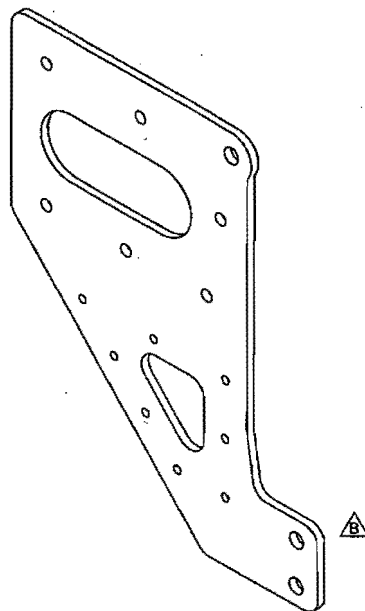
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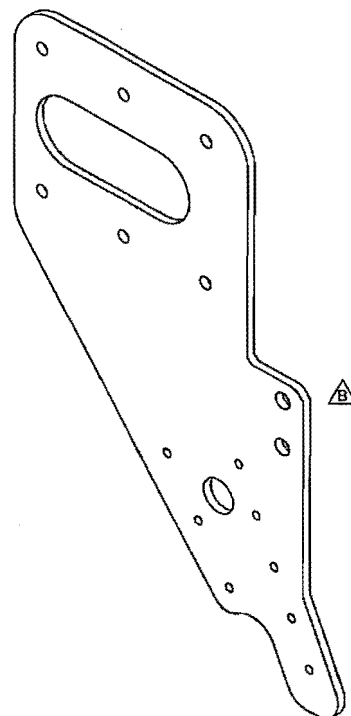
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D4274-1 PLATE, FWD SUPPORT



D4274-3 PLATE, AFT SUPPORT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68143

11-06-7

RELEASED
2010-08-06

B	D4274-1, D4274-3 PLATES LENGTH INCREASED BY 0.25"; HOLES OPENED TO 0.25" FOR AN4 BOLTS	SC	10.12.02
A	NEW ISSUE	SC	10.11.30
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4274	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	PLATES, BASKET SUPPORT	NTS
DATE	10.12.02	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

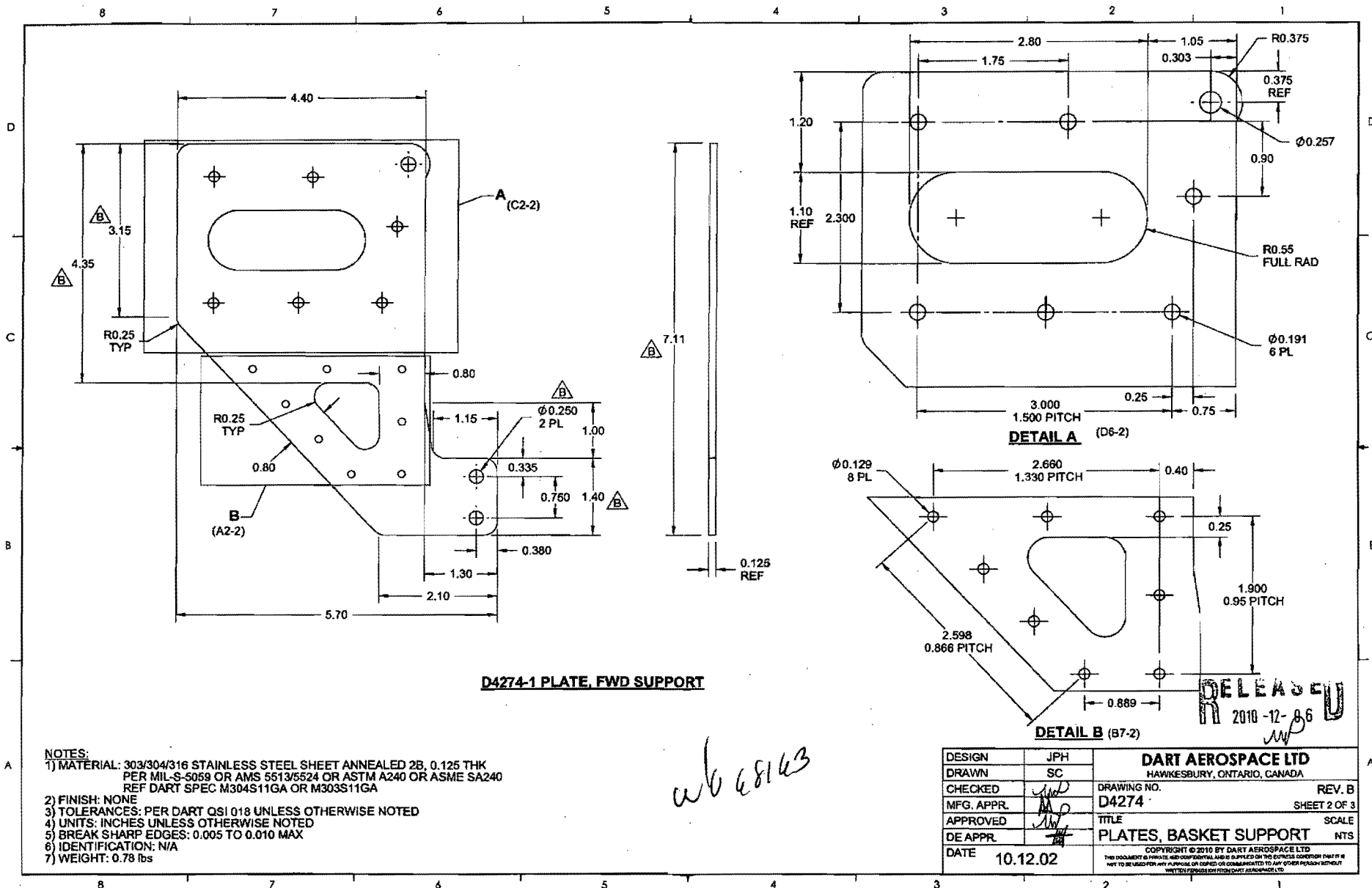
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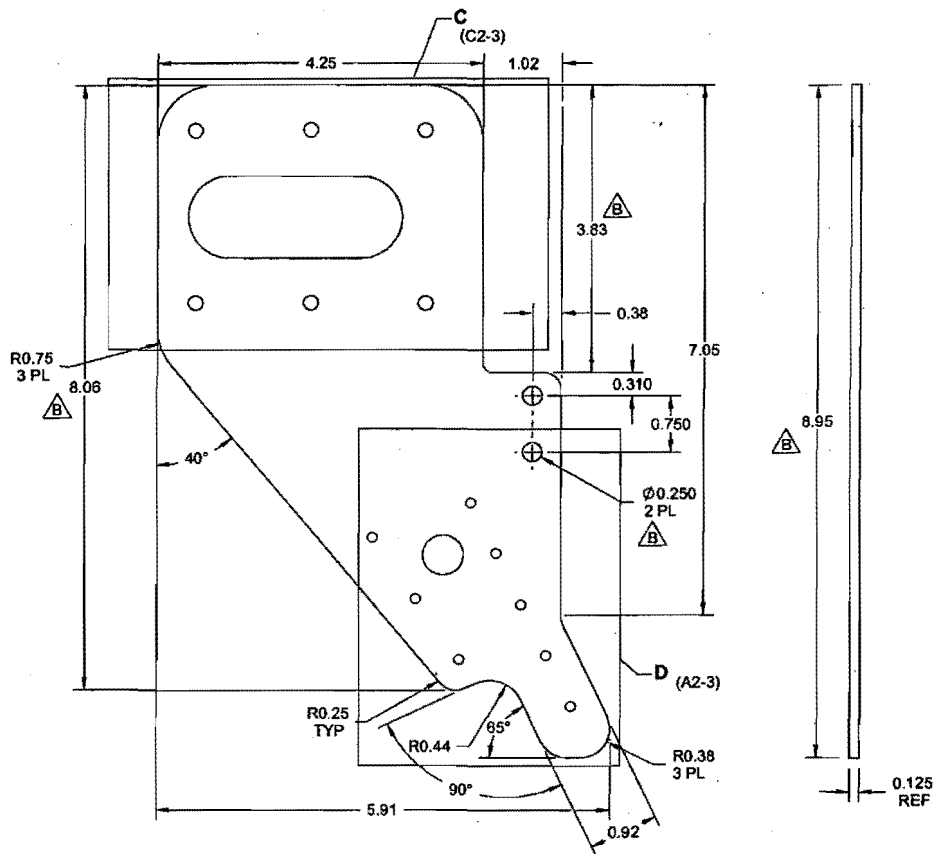
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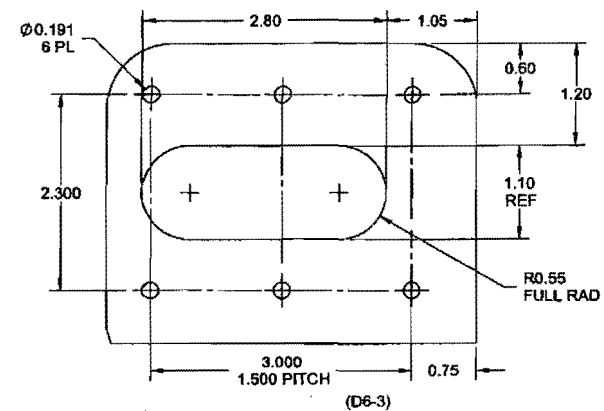
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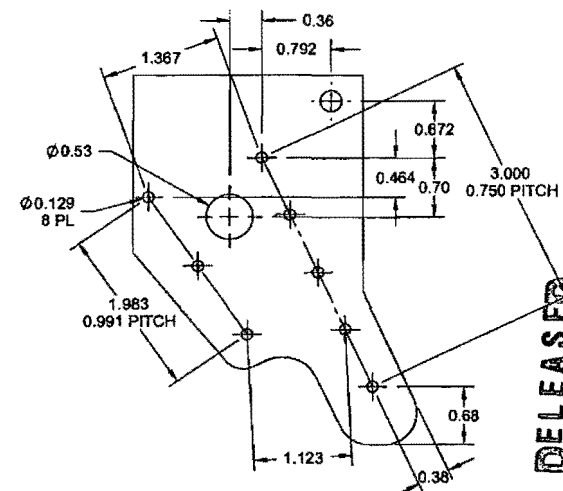
D4274-3 PLATE, AFT SUPPORT

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5613/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.97 lbs



DETAIL C



DETAIL D

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MP	DRAWING NO.	REV. B
MFG. APPR.	MP	D4274	SHEET 3 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	PLATES, BASKET SUPPORT	NTS
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RELEASED
2010-12-06

w/o 48143

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